

Work Order ID 56322

Page 1

February 17, 2010 2:38:30 PM

Item ID: D3784-044

Accept



Setup Start



Revision ID:

Item Name: Seat Support Assembly, RH

Stop



Start Date: 2/17/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

M

Date: 10/21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3784	Rev B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

110

Small Fab	0.00								
Small Fab	Memo	0.00							
Small Fab									

1-assemble as per dwg D3784****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented down****;****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented forward****

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

Sister 1/29

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 247

0.00

B143/29 E

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

10/04/10 HJ

QC

Memo

0.00

Quality Control

*M10-3-29
(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

February 17, 2010 2:38:34 PM

Work Order ID: 56322



Parent Item: D3784-044



Parent Item Name: Seat Support Assembly, RH

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R20		Purchased	No			110	Each	45.0000	16.0000	21	/	

Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	45	
113524	45	<u>11X</u>
Purchased	No	110 Each 3.445.000 16.0000

✓ M114227 5x

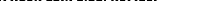
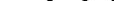
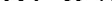
AN960JD10L



Washer

QSI NASII49PO 332]

MII2794 (6x)

D3763-041 Manufactured No 110 Each 4.0000 8.0000
    *05/03/29*

End Fitting Assembly



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST251	4	
54314	1	
55380	3	

3
356554 84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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February 17, 2010 2:38:34 PM

Work Order ID: 56322



Parent Item: D3784-044



Parent Item Name: Seat Support Assembly, RH

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3763-044		Manufactured	No			110	Each	0.0000	4.0000		B56596	EJ 10/03/29
End Fitting Assembly, RH												
D3770-1		Manufactured	No			110	Each	10.0000	4.0000			EJ 10/03/29
Tube												
				<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST			10					
				54316			10					
D3770-3		Manufactured	No			110	Each	17.0000	4.0000			
Tube												
				<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST			17					
				42963			1					
				54318			16					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56322



Parent Item: D3784-044



Parent Item Name: Seat Support Assembly, RH

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			110	Each	2,661.000	16.0000			



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2655	
110844	35	
111274	27	
111668	52	
112314	285	
112385	498	
113523	58	
113537	700	
113644	1000	
Main Warehouse		
ST139	6	
111668	6	

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Shop Packet Print

Page 3

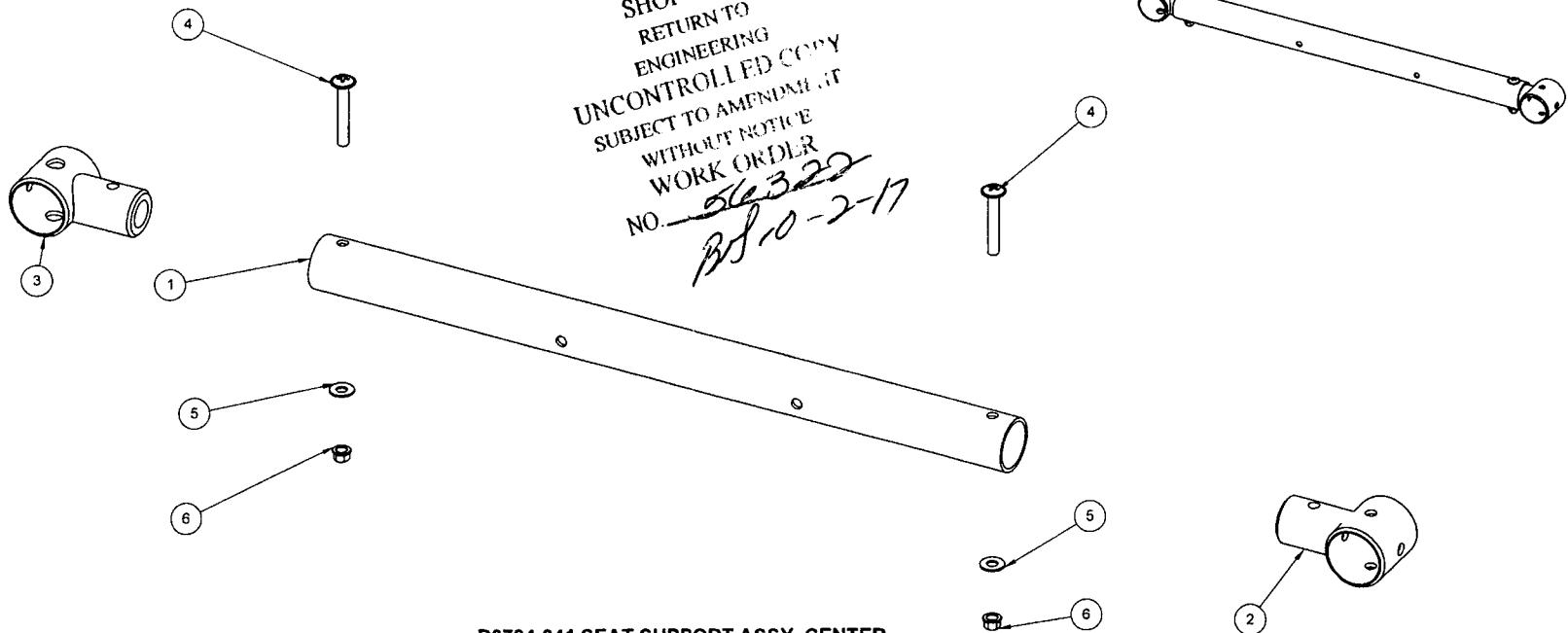
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 56322
 BY 10-2-17



D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

(B)
(B)
(B)
(B)

B	HARDWARE CHANGE, ASSY CHANGE		HS	08.06.23
A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION			BY DATE
DESIGN	HS	DART AEROSPACE LTD		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	M	DRAWING NO.	REV. B	
MFG. APPR.	M	D3784	SHEET 1 OF 5	
APPROVED	M	TITLE	SCALE	
DE APPR.	M	SEAT SUPPORT ASSEMBLY	NTS	
DATE	08.06.23			

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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

8 7 6 5 4 3 2 1

D

C

B

A

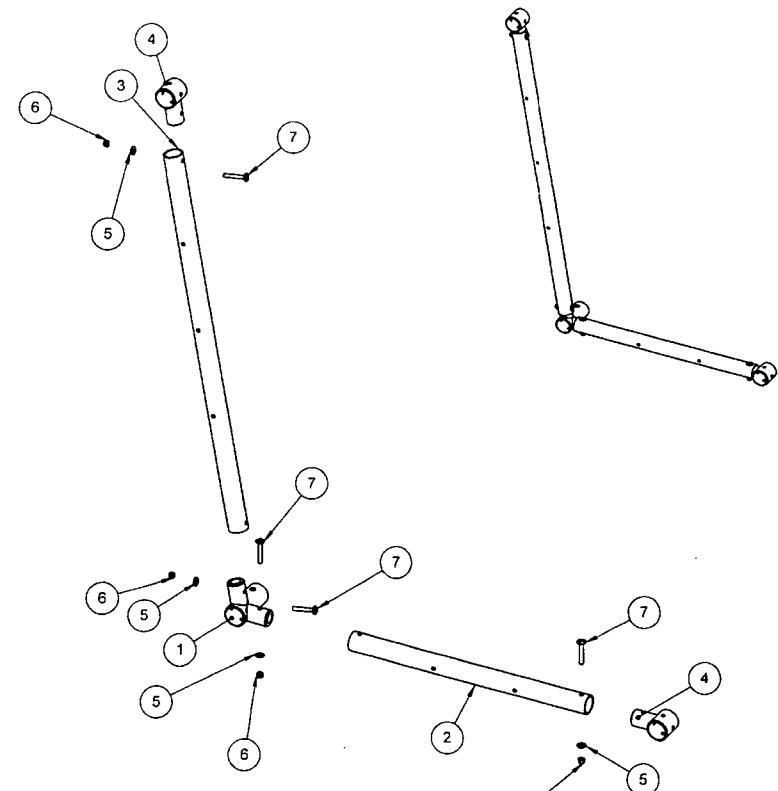
D

C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

B
B
BD3784-043 SEAT SUPPORT ASSY, LH

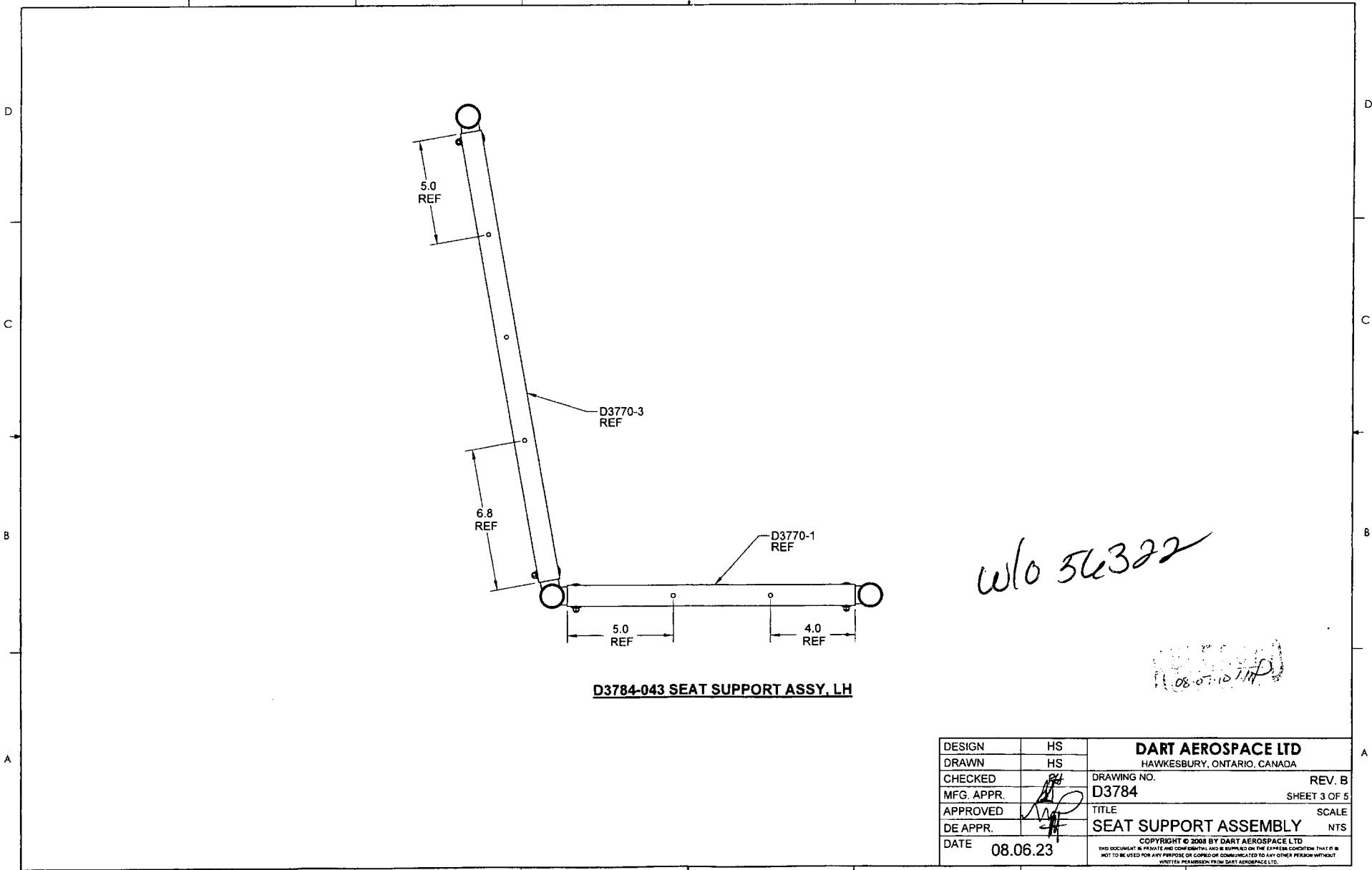
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11/07/10

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: .005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P/B	DRAWING NO.	
MFG. APPR.	M/D	REV. B	
APPROVED	M/D	D3784	
DE APPR.	M/D	SHEET 2 OF 5	
DATE	08.06.23	TITLE	
		SCALE	
		SEAT SUPPORT ASSEMBLY	
		NTS	
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		WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

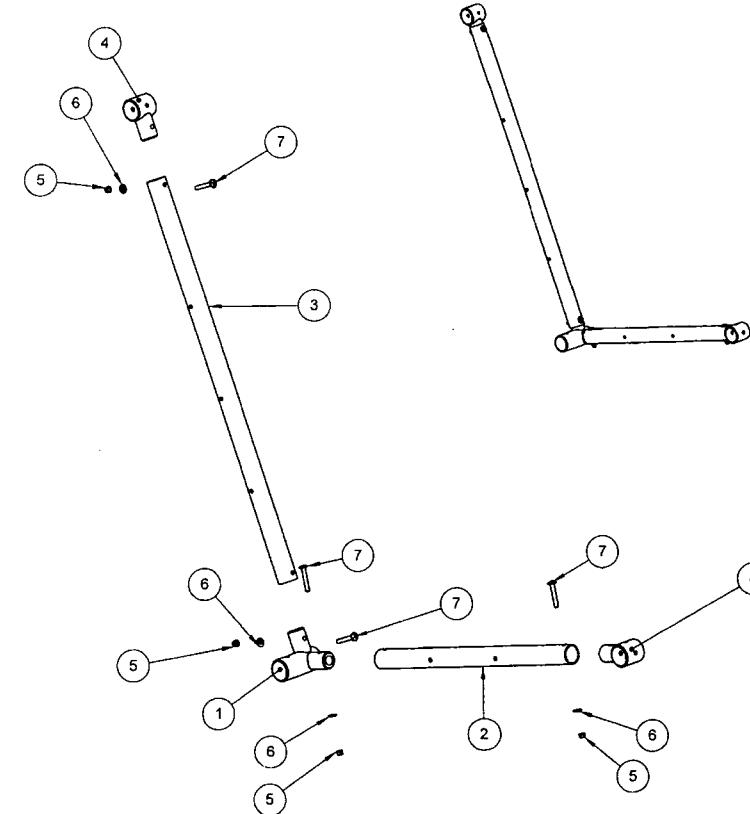
D

C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

B
B
BD3784-044 SEAT SUPPORT ASSY, RH

W/0 54328
11/05/2013

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI J18 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD			
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	AP	DRAWING NO.			
MFG. APPR.	NP	REV. B			
APPROVED	NP	D3784			
DE APPR.	NP	SHEET 4 OF 5			
DATE	08.06.23	TITLE			
		SCALE			
		NTS			
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